



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D205-634-041

Job Sheet 201225



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		10/28/19	0.00	0.65	Skidtubes - Bend		Mac
120	Skidtubes - 2 - B4B	1 pcs		10/28/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		Mac
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		10/28/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: 3227742



Part: D205-634-041

Job No: 201225

Serial No/Batch: 3227742

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3 FAA STC SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

140 Skidtubes - 3 - B4B	1 pcs	10/28/19	0.00 3.00	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	1766
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	10/28/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	10/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/28/19	0.00 1.31	Handfinish - 1 - 1 - B4B	BEB 19-11-15
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 -	

						B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
180	Powdercoat - 1 White GI(A)- B4B	1 pcs	10/28/19	0.00 0.34		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-11-18
						Powdercoat - 4 - B4B	
190	QC 3	1 pcs	10/28/19	0.00 0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 19-11-19
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
200	Handfinish - 4-1-Assembly- B4B	1 pcs	10/28/19	0.00 1.00		Handfinish - 4 - 1 - B4B	HL 19-11-19
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	

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					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
210	QC 5	1	10/28/19	0.00 0.00	QC 5 - 10	
		pcs			QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
220	Packaging 3-1 - Stock - B4B	1	10/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
225 DC - 1 - B4B	1 pcs	10/28/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	21
230 QC 21 - FG	1 pcs	10/28/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	21
				QC 21 - FG - 53	21

Part Op 110 - Skid tubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube

120 - Skid tubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skid tubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert

D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube

expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates

using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit

web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using

DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 1:45 OVEN TEMPERATURE: 300

FINISH TIME: 1:15

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes

before installing wearplates A/R Sikaflex-291 520062 Sikaflex expire date: 20-7-22 2-Coat D2594-3 O' rings with

Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft

Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 520062

Sikaflex expire date: 20-7-22 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 52006362

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: PPP Rev:

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skid tubes - Bend - 1	5209291
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skid tubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skid tubes - 3 - B4B	5184047
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5209194
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5228681
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5229062
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5045547
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196397
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5207800
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208675
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208804
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5225629
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178379

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	11	0
140-Skidtubes - 3 - B4B	D2576-3	1	70	0
	D4202-1	20	700	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,502	0
	AN3-5A	2	272	0
	AN3C4A	50	484	0
	D2594-1	16	59	0
	D2594-3	16	466	0
	D2855	1	78	0
	D3564-11	1	9	0
	D3564-13	1	26	0
	D3564-5	1	19	0
	D3564-9	1	18	0
	NAS1149C0332R	50	2,501	0
	NAS1149D0332J	2	1,766	0
Part Specifications				
Specifications could not be found.				

Plex 9/27/19 10:59 AM Dart.lajeunesse.marie

ITEM	QTY -041	QTY -045	QTY -047	QTY -048	DESCRIPTION
1	X				SKIDTUBE ASSEMBLY
2		X			SKIDTUBE ASSEMBLY
3			X		SKIDTUBE ASSEMBLY
4				X	SKIDTUBE ASSEMBLY
20	1	1	1	1	EXTRUSION
21			10	10	BUSHING
22	1	1	1	1	STEP
23		4			SPACER
24	10	10	8	8	PLUG
25	10	10	8	8	O-RING
26	1	1	1	1	200 WEB
27	1	1	1	1	AFT CAP
28	1	1	1	1	WEARSHOE
29	1	1	1	1	WEARSHOE
30	1	1	1	1	WEARSHOE
31	1	1	1	1	WEARSHOE
32	20	20	24	24	SPACER
33			1	1	WEARPLATE ASSEMBLY
34			1	1	WEARPLATE ASSEMBLY
35					PHD WEARPLATE
36			1	1	AFT WEARPLATE
60	60	60			INSERT
					AL37-1032-130 or AK57-1032-130 or AK54-1032-130 or AEL5-1032-100
91	60	60			AN50A
92	2	2	2	2	BOLT
93			8	8	BOLT
94	60	60			WASHER (AN500210L)
95	2	2	2	2	WASHER (AN500302L)
96			8	8	NUT (OR AN51048L)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART Q81 006 4.1 PRIOR TO INSERTING D2690 WEB
POWDER COAT (JAN-1477-049) GLOSS WHITE (REF 4.3.5.1) PER DART Q81 006 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART Q81 006 4.4.
- 3) TOLERANCES ARE PER DART Q81 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2690-041 = 55.7 lbs
D2690-047 = 33.7 lbs
D2690-049 = 45.1 lbs
D2690-049 = 32.0 lbs
- 8) WELDING PER DART Q81 004.
- 9) INSERT D2690 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SHAPLEX-341 ADHESIVE PER DART Q81 015 BEFORE
BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTR817 & DTR887 ONLY FOR D2690-041-048 TO LOCATE AND DRILL
Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL37-1032-130 PER SECTIONS B-B AND F-F (Ø
PLACES) AFTER FINISH. INSTALL AN50A BOLTS AND WASHERS WASHERS WITH
SHAPLEX-341-391.
- 12) INSERT D2690-1 PLUG CW D2690-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER
FINISH (16 PLACES FOR D2690-041-048 AND 8 PLACES FOR D2690-047-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2690 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

REV.	DESCRIPTION	DATE
H	SHEET: PL DELETE D2690-1/6-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER D81 9888	14.04.09
F	INCORPORATE DED D2690-5-1 PER PART-216	13.08.00
E	ADD D2690-047 (2N C4-7) AND D2690-7 (2N B3-9); INCLUDED DED D2690-0-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR817 & DTR887 WAS T26977-305 (2N C4-1)	11.08.01
D	CHANGE TO S8 WEARPLATES AND GASKETS	07.04.06
C	REDRAWN, INCLUDED DED 006/ 007	06.08.06
B	AS MANUFACTURED	06.12.02
A	NEW ISSUE	06.08.10
REV.	DESCRIPTION	DATE
DESIGN	DS	BY
DRAWN	SAD	
CHECKED	15	
INFL. APPR.	D2690	
APPROVED	TITLE	SHEET 1 OF 8
DE APPR.	205 SKIDTUBE ASSEMBLY	SCALE
DATE	17.06.09	NTS

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EART-549

201225 M15

14-05-27

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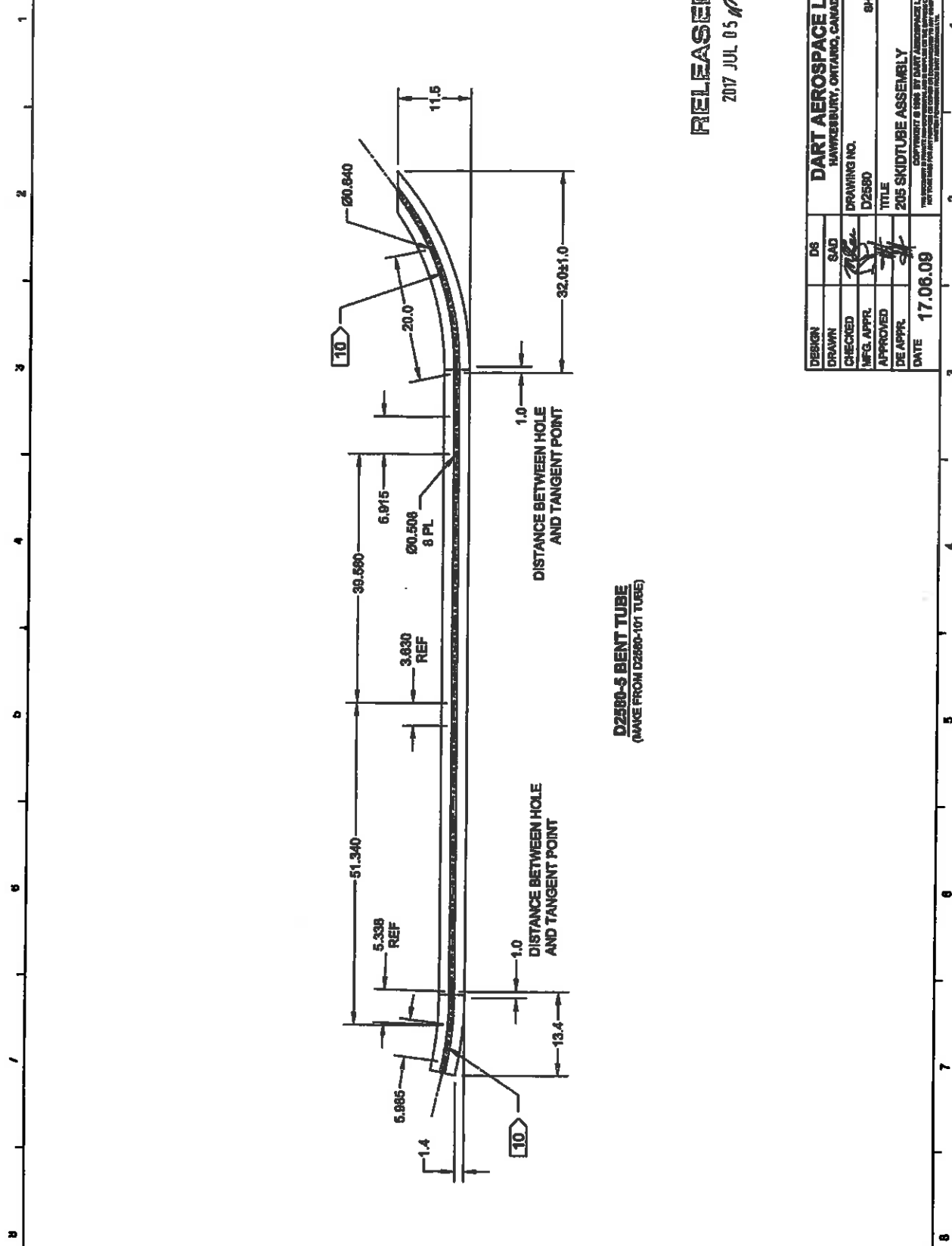
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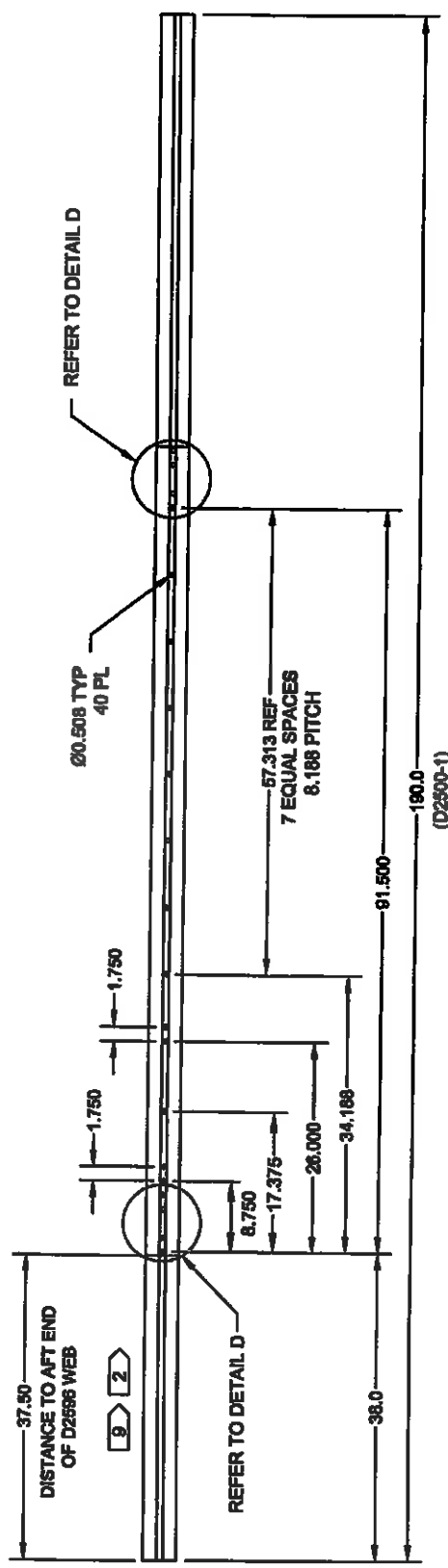
DESIGN	D8	DART AEROSPACE LTD HAWTHESBURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2590	SHEET 3 OF 8
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.08.09	CONFIRMED BY DART AEROSPACE LTD AUTHORIZED BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD	



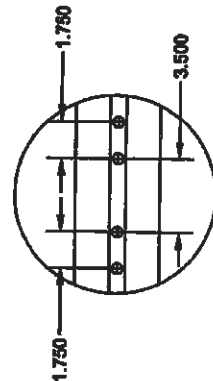
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05 *g*

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580
MFG. APPR.	<i>[Signature]</i>	REV. H SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE NTS
DATE	17.06.09	CONFIDENTIAL & UNCLASSIFIED BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.



D2588-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HANESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D2588
APPROVED		TITLE
DE APPR.		205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NT8

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ Eng. (Non-AW) ☐ ☐ Machining ☐ ☐ Prod. Eng. Coord. ☐ ☐ Large Fab ☐ ☐ Rec/Store/Packaging ☐ ☐ Engineering ☐ ☐ Water Jet ☐ ☐ Supplier ☐ ☐ Quality ☐ ☐		MRB (QS1042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																													
Description Work Order Deviation				Completed By																															
_____				Lead hand / Supervisor																															
_____				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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